

503

1-00

Work Order ID 85219

85219

Page 1

Item ID: D3954-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: GWT Pin

Start Date: 04/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 12/06/04

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3954

C

100

0.00

100

Doosan

Doosan Lathe

Memo

0.00

1-Turn as per folio FA824 & dwg D3954

FOLIO REV: WJADWG REV: C

2-Deburr as required

SA 125715

8 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

SA 125715

8 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 85219

June-04-12 3:50:01 PM

85219

Page 2

Item ID: D3954-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: GWT Pin
 Start Date: 04/06/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 18/06/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|-------------|--------------|---------------|---------------|------------------|-----------------|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | OK 12/07/05 | | 8 | 0 | | |
| 150 *150* Packaging Packaging | Identify as per dwg & Stock Location: 74 Memo | 0.00 0.00 | | | | (8/10) | | | 12/7/10 SP |
| 160 *160* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | OK 12/7/10 | | | | | YMF 12-07-10 |

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NOTE: Date & initial all entries

Picklist Print

June-04-12 3:50:05 PM

Page 1

Work Order ID: 85219

85219

Parent Item: D3954-1

D3954-1

Parent Item Name: GWT Pin

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M303R1.000

Purchased

No

100

f

28.6822

0.24

1.92

M303R1 000

**

SA 12/7/15

303 Round Bar 1.00

Location

Loc Qty

Loc Code

MAT028

28.68215789

120866

12

121070

3.31515789

121282

11.85

121728

1.517

2 Reet

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

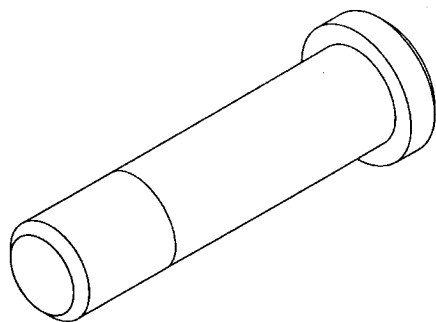
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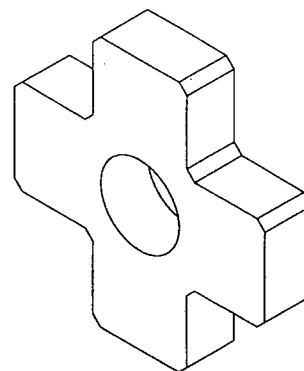
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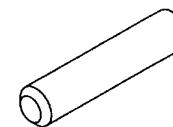
NOTE: Date & initial all entries



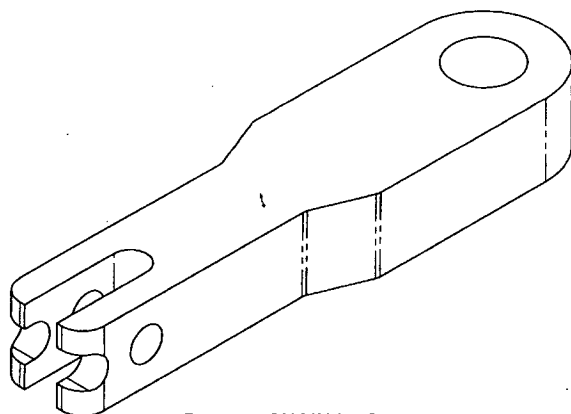
D3954-1 GWT PIN



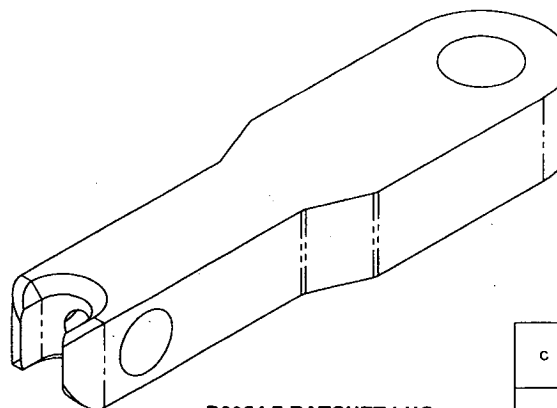
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85219 MLJ
12106104

RELEASED
2011-07-29

| | | | |
|---|---|---|--------------|
| C | MATERIAL UPDATE FOR D3954-1/-3: NOW STAINLESS STEEL ONLY (A8-2); FINISH CHANGED TO "NONE" FOR D3954-1/-3 (A8-2); TOLERANCE ON Ø0.750 WAS Ø0.75 MAX (D3-3 & D7-3); D3954-9 NOW A PURCHASED PART (A2/A8-3). REASON: PART11-113. | MB | 11.07.27 |
| B | MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT. | AJS | 09.10.15 |
| A | NEW ISSUE | AJS | 09.05.26 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS/DSTOW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | DRAWING NO. | REV. C |
| CHECKED |  | D3954 | SHEET 1 OF 3 |
| MFG. APPR. |  | TITLE | SCALE |
| APPROVED | | MISC MACHINED PARTS GWT KIT | NTS |
| DE APPR. | N/A | DATE 11.07.27 | |
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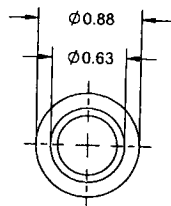
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

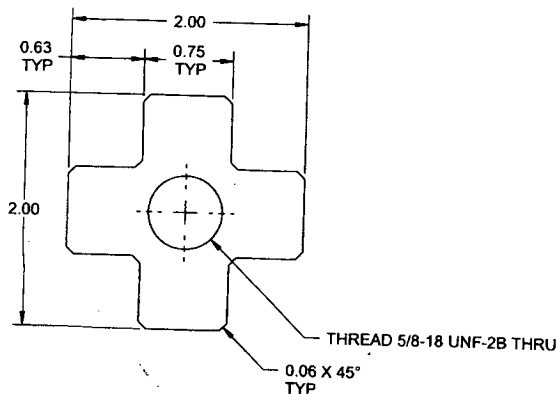
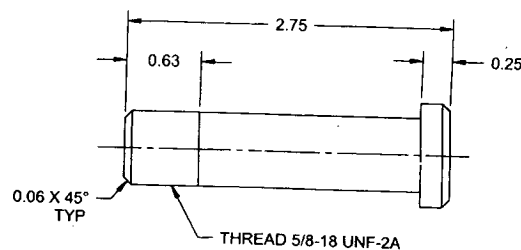
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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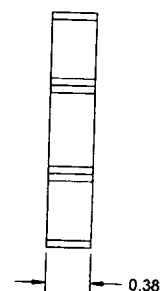
NOTE: Date & initial all entries



D3954-1 GWT PIN



D3954-3 GWT KNOB



NOTES:

1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR
PER ASTM A582 (303) OR ASTM A276 (304/316)
REF DART SPEC M303R OR M304R

-3: AISI 303/304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S OR M304S

OR:
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.26 lbs

-3: 0.23 lbs

RELEASED
2011-07-29

| | | | |
|------------|-----------|--|--------------|
| DESIGN | AJS/DSTOW | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3954 | REV. C |
| MFG. APPR. | | TITLE | SHEET 2 OF 3 |
| APPROVED | | MISC MACHINED PARTS GWT KIT | SCALE |
| DE APPR. | N/A | | NTS |
| DATE | 11.07.27 | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

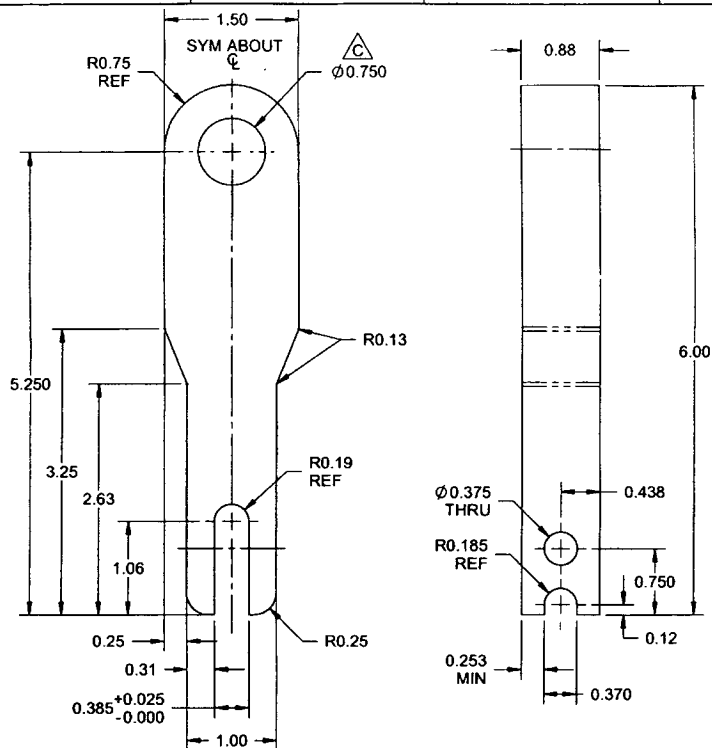
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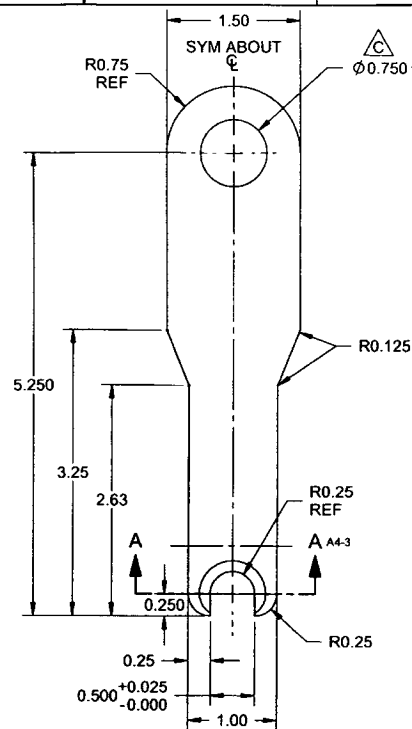
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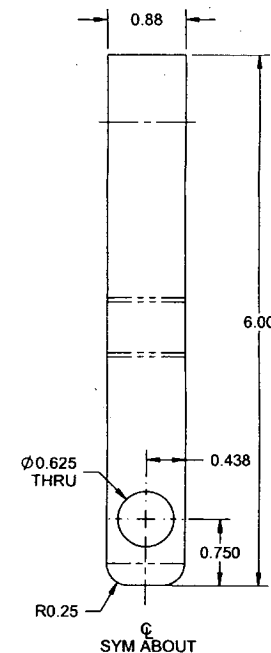
NOTE: Date & initial all entries



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG



D3954-9 GWT CHAIN PIN

NOTES:

1) MATERIAL:

-5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 98381A630 (MILD STEEL)

ALTERNATE MATERIAL:

-5/-7: AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B

-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 90145A630 (STAINLESS STEEL)

2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

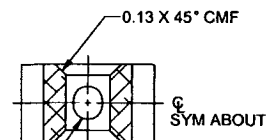
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

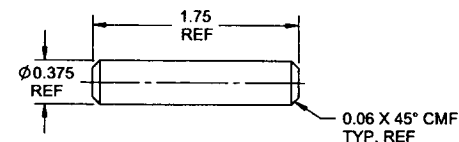
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -5/-7: 1.56 lbs EACH

-9: 0.05 lbs REF



SECTION A-A C3-3



| | | | |
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| DESIGN | AJS/DSTOW | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AJS | DRAWING NO. D3954 | REV. C |
| MFG. APPR. | | | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | N/A | MISC MACHINED PARTS GWT KIT | NTS |
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2011-07-29

85219

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